

Date: Monday, 22/09/2008 2:00:22 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY	
Job Number : 42189	Part Number : D3121141	
Estimate Number : 10278	Drawing Number : D3121 REV E	
P.O. Number :	Project Number : N/A	
This Issue : 22/09/2008 S.O. No. :	Drawing Revision : E	
Prsht Rev. : NC	Material :	
First Issue : / / Type : MACHINED PARTS	Due Date : 25/10/2008 Qty: 140 Um: Each	
Previous Run : 40250		
Written By : <u>L</u>		
Checked & Approved By :		
Comment : Est Rev:Pick:A 04.02.18 New issue KJ/DS Est Rev:B ECN 1060 07-11-12 DD verified by: EC Est Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC		
Additional Product		
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
1.0	M174B1250X02000 	17-4 SS Bar 1.250 x 2.00  84
Comment: Qty.: 0.5775 f(s)/Unit Total : 80.8500 f(s) Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.250x02.000) Identify for D3121-111 Batch: <u>M109457X84</u> 18.51 mm 08/09/24		<u>M109457X84</u> 18.51 mm 08/09/24 -32.34
2.0	BAND SAW 	BAND SAW  84
Comment: BAND SAW 1.250 Cut blanks: (1.000" x 2.000") 6.600" long		<u>M109457X84</u> 18.51 mm 08/09/24
3.0	HAAS1 	HAAS CNC VERTICAL MACHINING #1  <u>Issue P.O 7241</u> Globur 08/09/24 190
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111 2-Deburr 3-Scribe batch number		
4.0	 902	INSPECT PARTS AS THEY COME OFF MACHINE <u>Review + Inspect for transit damage</u> <u>Ensure C/S C 2ft 2in</u>  134
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 2:00:22 PM
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Process Sheet

(12)

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 42189

Part Number: D3121141

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK Inspect level 5



counter
S 08/11/20 4139

6.0 D312121 Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 140.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3121-21 Bolt B40351 61X

B40350 61X
B42201 88X



Ep08/11/21

7.0 D3121241 Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 140.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3121-241 Bearing Ass B39948 17X

B42177 22



Ep08/11/21

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



* Scribe Batch number *



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-141 as per Dwg D3121.

Ep08/11/24 139

9.0 QC5 INSPECT WORK TO CURRENT STEP



INSPECT WORK TO CURRENT STEP



counter
S 08/11/24 4139

Comment: INSPECT WORK TO CURRENT STEP

10.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST233

FINAL INSPECTION/W/O RELEASE

08/11/24
MF 08-11-25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

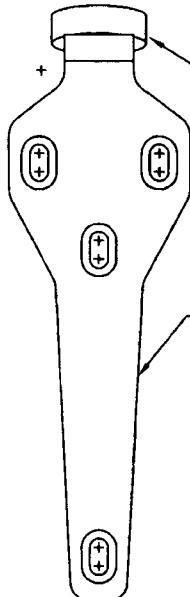
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>#</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>-</i>	DRAWING NO. D3121	REV. E SHEET 2 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2



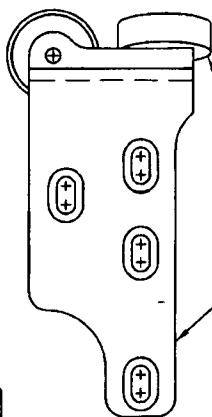
D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-111 BRACKET

D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

RELEASED
07.11.07 W

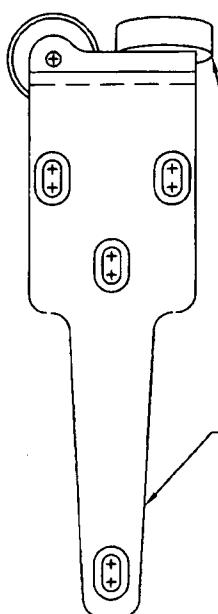
W/O 4289



D3121-21 BOLT (1)
D3121-241- BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

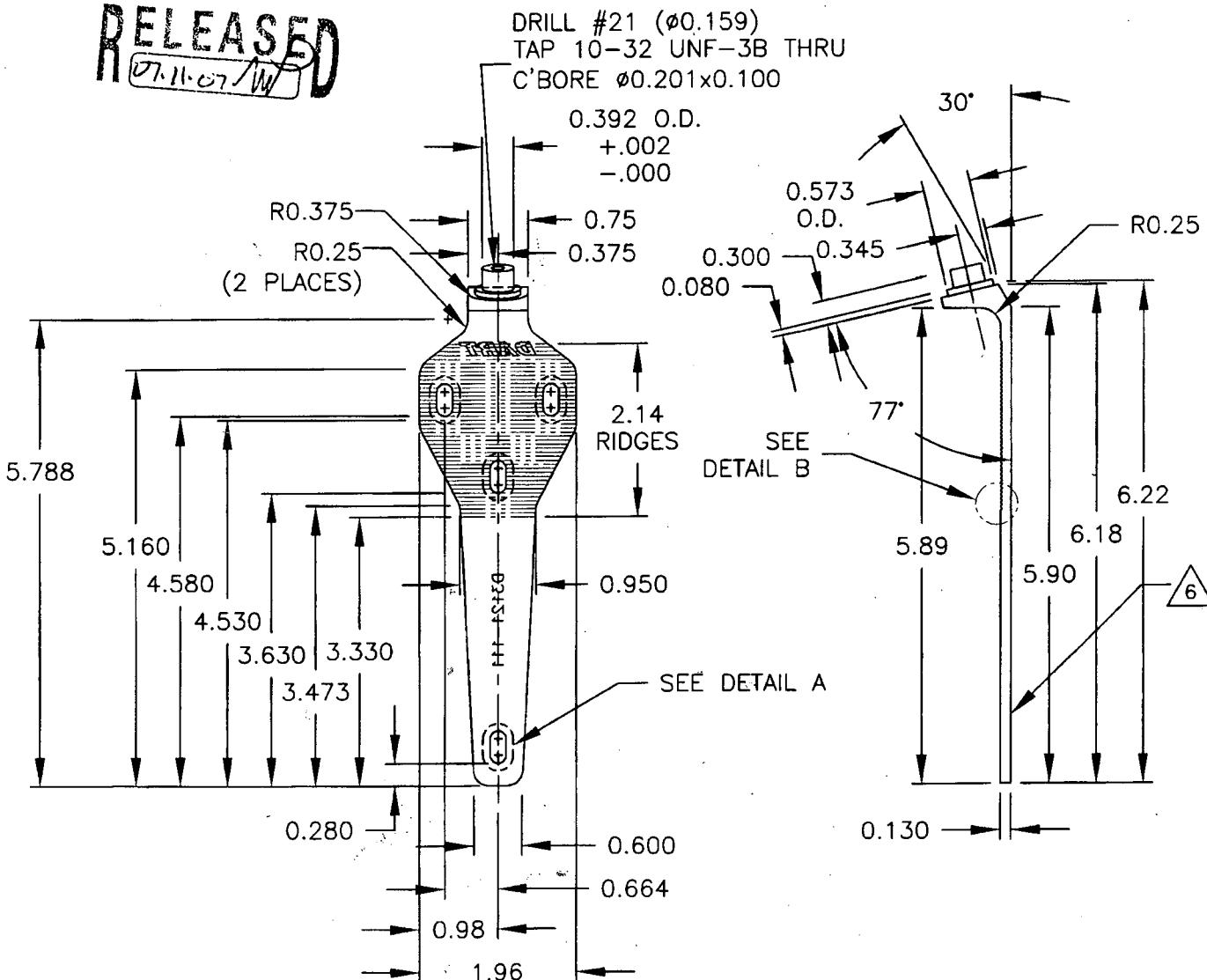
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>4</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>4</i>	APPROVED <i>4</i>	DRAWING NO. D3121	REV. E SHEET 7 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07**D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

No 42189

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

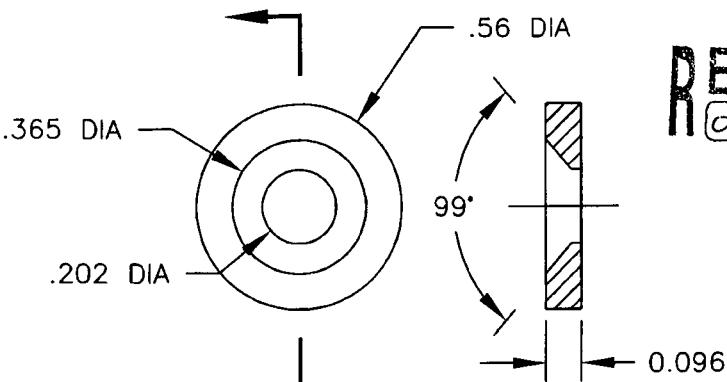
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

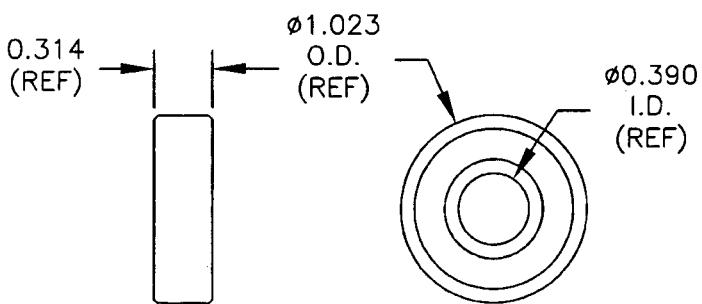
NOTE: Date & initial all entries

DART

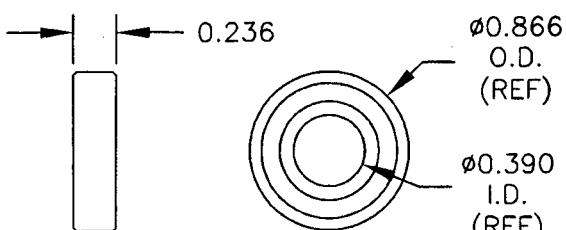
DESIGN <i>CH</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

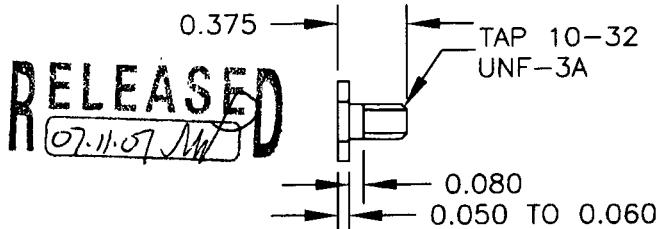
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

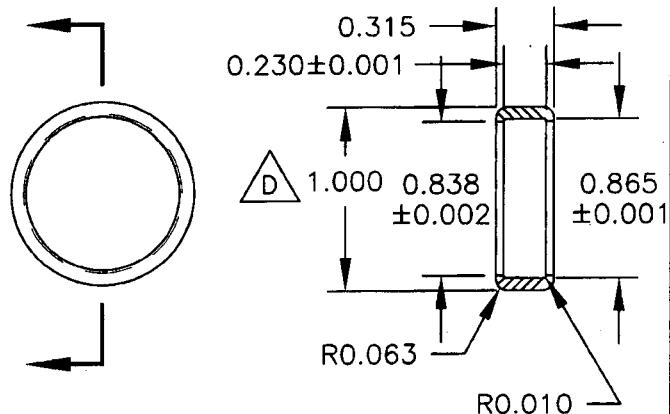
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

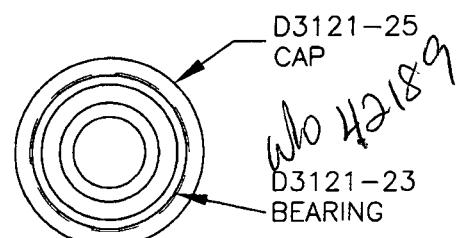
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Invoice

36 Colonnade Road N.

Ottawa, Ontario K2E 7J6

Tel: (613) 226-1579

Fax: (613) 226-1719

DATE	INVOICE NO.
11/14/2008	17343

BILL TO
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

SHIP TO
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
00007241	Net 30	11/17/2008	FedEx	812	Globus

QTY	DESCRIPTION	UNIT PRICE	AMOUNT
139	D3121141 Bracket Assembly Business Number: 102122058		

John D. 08.11.17

WHITE = Original
BLUE = C of C
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts



Invoice

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

DATE	INVOICE NO.
11/14/2008	17343

BILL TO		SHIP TO			
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7		Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7			
P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
00007241	Net 30	11/17/2008	FedEx	812	Globus
QTY	DESCRIPTION				
139	D3121141 Bracket Assembly Business Number: 102122058				
<p>WE CERTIFY THAT ITEMS LISTED HAVE BEEN MANUFACTURED IN ACCORDANCE WITH DRAWINGS AND PURCHASE ORDER SPECIFICATIONS</p> <p>AE</p> <p>11/17/2008</p>					

WHITE = Original
BLUE = C of C
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts